Work Orde March-12-13 1:	er ID 98470 56:40 PM			*98470*								
Revision ID:	D3929-041 Gusset Assembly			Accept	*N900	040	100)* s	etup Start Stop	1 31	S1*	
	3/06/13 Start Q	ty: 10.00 Qty: 10.00	*40 *40)* *12*)*	Cust Item I Customer:	ID:				IN	S2*	
Approvals	Process Plan:		Date: <u>1</u> 3-63			ate:		R	un Star Stop		R1* R2*	
Sequence ID/ Work Center II	Operati Descrip			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept_ Qty	Reject Qty	Reject Number	Insp. Stamp	
Draw Nbr	Revision Nb	•				».						
D3929	Rev A											
100				0.00								
100 Waterjet		Memo		0.00				12_	0		Ac. 11.0	
FLOW CNC Waterje		1-Cut as per Dwg Rev: Prog Rev:						يد د الله يا الله يا يو يود د الله يا الله يا يود				
		2-Deburr if	necessary					ţ ⁶				
110	QC2- Insp	ect parts off m	achine FAI/FAIB	0.00								

0.00

Memo

110

Quality Control

12 0 Ac 13.11.04

											DQA:	Da	te:	
NCR: Y	'es	/ No				WORK ORDER NON-O	O	VFORM	MANCE / UPDATE		QA Closed:	Da	te:	
						DISPOSITION			AGA	UNST DE	PARTMENT			
Work Orde	er:					DISPOSITION	_				,	T NOCESS		
		111				Rework			Skid-tube Cross	stube		Water Jet	-	Engineering
Part N	10.					Scrap	1		~ 	ll Fab	4	d. Eng. Coor.	-	Quality
						Use-as-is]		—	shing	Rec/Sto	re/Packaging		Other
NCR N	10.					Work Order Update]		Large Fab Comp	osite		Supplier	Ш	
				1							l 6: 0		—	
Root					1	ption of work order update	1	Initial	Action		Sign &		_	OC Imamaatan
Cause	\blacksquare	Date	Step	Qty	•	or Non-conformance	Cr	nief Eng	Description		Date	Verificatio	" 	QC Inspector
Doc/Data														
Equip/Tooling													1	
Operator														
Material														
Setup				ļ									ļ	
Other	-			Ì										
Process														
Supplier Training														
Unapproved														
Onapproved		l	<u> </u>	1			AUI	LT CATE	GORY			<u> </u>		
Landi	ng (Gear				General								
	_	Bending				Bend		Grain			Ovalized			Pressure/Forced
		Centre N	ot Conce	ntric to	o/s	BOM/Route		Hardwa	are		Over/Under	tolerance	П	Temperature/Cure
		Cracks				Broken/Damaged		Inspect	ion Incomplete	<u> </u>	Part Incorre	ct		Weld
		Crushed/	Crimped			Burrs		Instruct	tions Incomplete/Unclear		Part Lost/M	issing		Wrong Stock Pulled
	Г	Cuffs				Contamination		Mainte	enance		Part Moved			

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Positioned Wrong

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Work Orde		470		*98		Page 2			
Item ID: Revision ID: Item Name:	D3929-041 Gusset Assem	ibly		Accept	*N9000	14010	N* ^s	Setup Start Stop	*NS1* *NS2*
Start Date: Required Date: Reference:	3/06/13	Start Qty: 10.00 Req'd Qty: 10.00	*10° *10°		Cust Item ID: Customer:	:			
Approvals:		an:	Date:		Date			Run Start Stop	*NR1* *NR2*
Sequence ID/ Work Center II 120 *120* QC Quality Control	D	Operation Description QC8- Inspect parts - second	and check	Set Up/ Run Hours 0.00 Sy	Tool ID	Tool # Plan Code	Accept Qty		Reject Insp. Number Stamp
140 *1/10* Large Fab Large Fab			ngs D3907-1 as per dwg batch: <u>M/26</u> 0				(12)		Me 13.11.25
150 *150* QC Quality Control		QC9- Inspect visual per (•	0.00				13-11-20	DAS 9-89

											DQA:	Dat	e:
NCR:	Yes	/ No				WORK ORDER NON-	COI	VFORN	ANCE / UPI	DATE			
											QA Closed:	Dat	e:
Work Orde	or.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
WOIK OIG	-					Rework	٦		Skid-tube	Crosstube	7	Water Jet	Engineering
Part N	No.					Scrap	1 1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
''	10.					Use-as-is	1	Thermoforming Finishing			-	re/Packaging	Other
NCR I	No.					Work Order Update	1		Large Fab	Composite	1	Supplier	\dashv
	•				•	· ' <u> </u>	ر ر		°	'		٠٠ ر	
Root					Descri	ption of work order update		Initial	Act	tion	Sign &		
Cause		Date	Step	Qty	C	or Non-conformance	Ch	nief Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling								ļ					
Operator	Ш												
Material	Ш										1		
Setup			l	1								i.	
Other													
Process	Ш						1						
Supplier												ŀ	
Training	Щ												ļ
Unapproved			<u></u>	<u> </u>							1		<u> </u>
							AUI	LT CATE	GORY				
Landi	ng (•				General		1		F	٦	г	
	\vdash	Bending				Bend	\vdash	Grain		<u> </u>	Ovalized		Pressure/Forced
	\vdash	Centre N	ot Conce	ntric to (^{D/S} -	BOM/Route	\vdash	Hardwa		<u> </u>	Over/Under	i i	Temperature/Cure
	<u> </u>	Cracks	.		<u> </u>	Broken/Damaged	\vdash	4	on Incomplete		Part Incorre	}	Weld
	-	Crushed/	Crimped		<u> </u>	Burrs	\vdash	4	ions Incomplete/l	Unclear	Part Lost/M		Wrong Stock Pulled
	-	Cuffs			<u> </u>	Contamination	\vdash	Mainte		-	Part Moved		
	\vdash	Heat Tre		T l		Countersink	-	Mislabe			Positioned		Other
	\vdash	Inspectio		lube	<u> </u>	Cut Too Short	\vdash	Misread	1	L.	Power Loss,	Surge [Other
1	1	Ripples in	u Reua		- 1	Drill Holes	- 1	Offset					

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Ord March-12-13 1		3470		*984	17 0 *				Page			
Item ID: Revision ID:	D3929-041			Accept	*N900	040	100)* 9	Setup Star	I VI	S1*	
Item Name:	Gusset Assen	nbly							Stop	*N	S2*	
Start Date:	3/06/13	Start Qty: 10.00	*10*		Cust Item I	D:						
Required Date	: 3/22/13	Req'd Qty: 10.00	*10*		Customer:							
Reference:												
Approvals:	Process Pl	an:	Date:	Tooling:	Da	ate:		I	Run Star	17	R1*	
· •			Date:	SPC (Y/N):	Da	ate:			Stop	, *N	R2*	
Sequence ID/ Work Center I	ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
160		QC5- Inspect part comple	teness to step on W/O	0.00							DAS	
160 QC Quality Control		Memo		0.00				(D)	13-11-21	0	9-89	
170 * 1 70*		Identify as per dwg & Sto	ck Location: WA 06	of 0.00	0			12*	.			
Packaging Packaging		Memo		0.00	P(13.1	1.27	7	<u> </u>				
*180 *180*		QC21- Final Inspection -	Work Order Release	0.00			#	-/R	n 13/1	1/27.		
QC Quality Control		Memo		0.00				/	-			

NB 11-27

c /	No
	s /

													j 3
											DQA:	Date:	
NCR: Y	es	/ No				WORK ORDER NON	I-COP	NFORM	AANCE / UP	DATE	•		
											QA Closed:	Date:	
Work Orde	r:					DISPOSITION				AGAINST DI	EPARTMENT	/PROCESS	
Part N	-					Rework Scrap	_		Skid-tube Machining	Crosstube Small Fab	Pro	Water Jet d. Eng. Coor.	Engineering Quality
	•					Use-as-is	\dashv		noforming	Finishing	Rec/Sto	Other	
NCR N	lo.		· · · · · ·			Work Order Update			Large Fab	Composite		Supplier	
Root					Descri	iption of work order update	:	nitial	Ac	tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
oc/Data													
quip/Tooling													
Operator													
/laterial													
etup													
Other													
rocess													
upplier													
raining						•							
Inapproved													
							FAUL	T CATE	GORY	· · · · · · · · · · · · · · · · · · ·			
Landi	ng G	Sear				General		•		_	_		,
		Bending			L	Bend	`	Grain		_	Ovalized		Pressure/Forced
		Centre No	ot Concer	ntric to (o/s	BOM/Route	<u> </u>	Hardwa		<u> </u>	Over/Under	 	Temperature/Cure
		Cracks				Broken/Damaged		4 '	on Incomplete		Part Incorre	} —	Weld
		Crushed/	Crimped		L	Burrs		instruct	ions Incomplete/	Unclear	Part Lost/M	issing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte			Part Moved		
i	-	Heat Trea				Countersink		Mislabe	eled	L	Positioned \		,
		Inspection	•	Tube		Cut Too Short		Misread	t	L	Power Loss/	'Surge	Other
		Ripples in	Bend			Drill Holes		Offset					
		Torque W	/aves in E	Extrusio	n L	Drawing	<u> </u>	Out of 0	Calibration				
		Turning S	•			Finish		Out of S	Sequence				
		Wave/Tw	ist in Tul	be	ĺ	Folio		Outside	Dimensions				

March-12-13 1:56:40 PM

Work Order ID:

98470

Parent Item:

D3929-041

Parent Item Name:

Gusset Assembly

Start Date: 3/06/13

Required Date: 3/22/13

Start Qty: 10.00

Required Qty: 10.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA 304/316 0.125 Sheet		Purchased	No			100	sf	258.0000	0.45	4.7368421	A	13	11.04
				Location		Loc Qty	Lo	c Code				_	
\$				MAT020		258			\mathfrak{n}	120075	- 	5.	
				122	521	66							
, 10 mg mg				244	45	192							
D3907-1 Bushing		Manufactured	No			130	Each	92.0000	2	22)28	W	re	13-11.
of the first				Location		Loc Qty	Lo	c Code	`				
	- E.	0.0		WA004		52							į
B100	0314	x 22		888	91	1							
				896	88	1							
				952	15	15							
				963	02	35							
				WA007		40							
				967	46	40				<u> </u>			

											DQA:	Date	::	
NCR: Y	es /	/ No				WORK ORDER NON-	CO	NFORN	/IANCE / UPI	DATE	QA Closed:	Date	:	
Vork Orde	ri:					DISPOSITION	AGAINST DEPARTMENT/PROCESS							
Part N	 lo		.,			Rework Scrap Use-as-is		Therm	Skid-tube Machining Moforming	Crosstube Small Fab Finishing	 1	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other	
NCR N	io		· · · · · · · · · · · · · · · · · · ·			Work Order Update	┛╽		Large Fab	Composite		Supplier		
Root Cause		Date	Step	Qty	Desc	cription of work order update or Non-conformance	1	nitial nief Eng		tion ription	Sign & Date	Verification	QC Inspector	
oc/Data quip/Tooling perator Material etup other rocess upplier raining						·								
							FAUL	LT CATE	GORY	**************************************				
Landii	ding Gear Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion Bend Bend Bom/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish				Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing		Instruct Mainte Mislabe Misread Offset Out of (ion Incomplete ions Incomplete/ enance eled d	Unclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct issing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other		
		Turning S Nave/Tw				Finish Folio	\vdash	-	Sequence Dimensions			<u></u>	·	

DART AEROSPACE LTD	Work Order:	98470
Description: Support Gusset	Part Number:	D3929-1
Inspection Dwg: D3929 Rev: A		Page 1 of 1

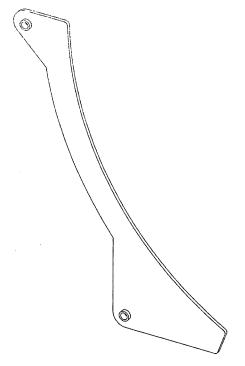
FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

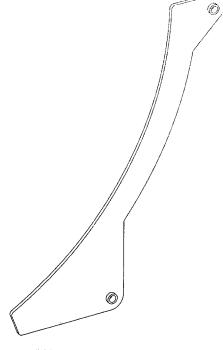
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.375	+0.006/-0.001	-377			٧	JKM-01
0.500	+/-0.010	.500	_		٧	
0.500	+/-0.010	,500	_		· V	
4.036	+/-0.010	4.036			V.	
4.382	+/-0.010	4.382	_		V	
8.274	+/-0.010	8.274			T	
10.915	+/-0.010	10.915			+	
1.000	+/-0.010	1.000			>	
11.198	+/-0.010	11.198	-		۲	
0.500	+/-0.010	.500			>	
1.572	+/-0.010	1.579	_		V	
0.125	+/-0.010	011	400-		>	

Measured by: Ae	Audited by:	SMP	Prototype Approval:	N/A
Date: 13 - 11 - 04	Date:	13 11 04	Date:	N/A

A 09.05.27 New Issue P/O D3929-041/-042	KJ ox	<i>X</i>



D3929-041 GUSSET ASSEMBLY



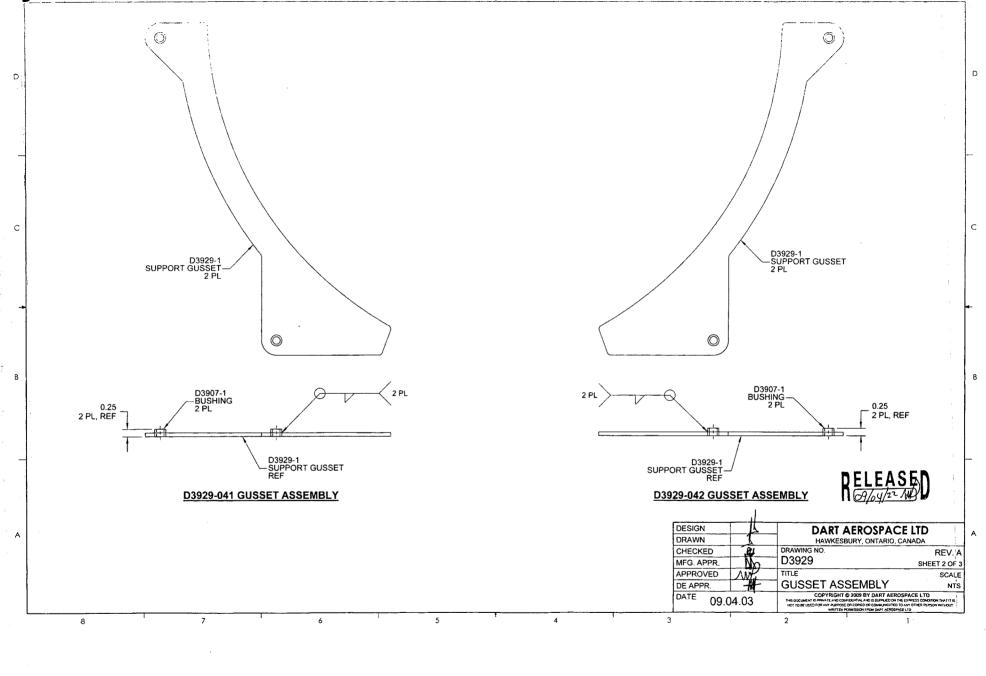
D3929-042 GUSSET ASSEMBLY

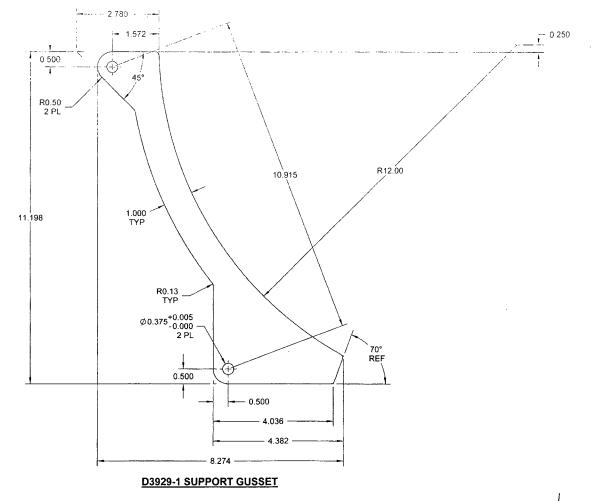
D3929-041 GUSSET ASSEMBLY D3929-042 GUSSET ASSEMBLY D3907-1 BUSHING SUPPORT GUSSET

SHOP JOHY RETURN 10 ENGINEERING UNCONTROLLED COPY SUBJECT TO A JETS JUNENT WITHOUT SCHOE WORK ORDING
NI 98470 MC3
13-03-13

					· · · · · ·	
Α	NEW ISSU	E		MB	09.04.03	
REV.		J	DESCRIPTION	BY	DATE	
DESIGN		4	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN 🙏		کے				
CHECKED		PH	DRAWING NO.		REV. A	
MFG. APPR.		_ W	D3929		SHEET 1 OF 3	
APPROVED ($\Lambda \mathcal{M}_{i}$	TITLE		SCALE	
DE APPR.		4	GUSSET ASSEMBLY NT			
DATE 09.04.03			COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PROVITE AND CONFIDENTIAL, MOIT SUPPLIED ON THE PERPERS CONDITION THAT IT IS NOT TO BE USED FOR MY PURPOSE OR COPPED OR COMMUNICATED TO ANY OTHER PERISON WITHOUT WRITTEN PERISON FROM MORT JAGOSPACE LTD			

NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3929-04X" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.73 Ibs EACH
8) WELDING: PER DART QSI 004





5

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
11 GAUGE (0.125 THICK)
REF. DART SPEC. M304S11GA
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.72 lbs

8

DESIGN / JA		DART AEROSPACE LTD		
DRAWN		HAWKESBURY, ONTARIO, CANADA		
CHECKED	PH.	DRAWING NO.	REV. A	
MFG. APPR.	\mathcal{M}_{\sim}	D3929	SHEET 3 OF 3	
APPROVED	TAN	TITLE	SCALE	
DE APPR.		GUSSET ASSEMBLY	NTS	
DATE 09.04.03		COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS GOOLAGE! IS TRIVINE AND COMPONENT AND ITS SUPPLIED ON THE EXPRESS CONDITION THAT ITS NOT TO BE USED FOR ANY ARROSS OF GOOD OR COMMANDATION FOR FOR THE PRIESDA WITHOUT		

3

		The state of the s			•	
X						
3 4.						
	and the second					- Table 1
		•		***		
			•			
		•				
, £			·			
						†
				•		
21						
	The state of the s					**************************************
	The state of the s					_ %
	en e					
i i				•		
7		,				
	지수는 사람들이 가장 기계를 받는 것이 되는 것이다. 그 것이 되는 것이 되는 것이 되는 것이 되는 것이 되었다. 그는 것이 되는 것이 되는 것이다. 그는 것이 되는 것이 되는 것이 되었다. 그는 것이 되는 것이 되었다면 되었다면 되었다면 되었다면 되었다면 되었다면 되었다면 되었다면					
		•				
En.						
						·
•						
		and the second s				